








# Work Order ID 73951

Tuesday, September 20, 2011 10:16:45 AM

Page 1


Item ID:	D4330-3	Accept		Setup	Start	
Revision ID:						
Item Name:	Door Bracket				Stop	
Start Date:	9/20/2011	Start Qty: 6.00		Cust Item ID:		
Required Date:	10/4/2011	Req'd Qty: 6.00		Customer:		
Reference:						

Approvals:	Process Plan: <u>mf</u>	Date: <u>11-09-20</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4330	A								


100		0.00							
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	FLOW WATER JET								
Waterjet		0.00							
FLOW CNC Waterjet	Memo								
6061 -080	1-Cut as per Dwg								
	Dwg Rev: <u>A</u>								
	Prog Rev: <u>D</u>								
	2-Deburr if necessary								

B 11-9-20


(1)

110		0.00							
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	QC2- Inspect parts off machine FAI/FAIB								
QC		0.00							
Quality Control	Memo								

B 11-9-20

120		0.00							
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	QC8- Inspect parts - second check								
QC		0.00							
Quality Control	Memo								

8/11/09/2

(x11)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 73951**

Tuesday, September 20, 2011 10:16:45 AM

Page 2

Item ID: D4330-3

Accept

Revision ID:

Item Name: Door Bracket

Start Date: 9/20/2011 Start Qty: 6.00

Required Date: 10/4/2011 Req'd Qty: 6.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start  
StopSequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Bend as per dwg  
NC BRAKE

0.00



Brake NC

Memo

0.00

Brake NC

SB 11/09/29

(11)

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 11/09/29

(11)

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

11 BL 11-9-29.

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries



**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, September 20, 2011 10:16:43 AM

Page 1

Work Order ID: 73951

Parent Item: D4330-3

Parent Item Name: Door Bracket



Start Date: 9/20/2011

Required Date: 10/4/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 11.02.17 new issue DD verified by: EC IPP REV:B  
11.08.18 per dwg revA. DD Verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.080

Purchased

No

100

sf

116.3000

0.1402

0.885474

1.5



11-9-20

6061-T6 .080 Sheet

Location

Loc Qty

Loc Code

MAT021

116.3

116268

9.5

117285

106.8

116268

11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

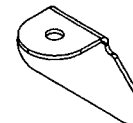
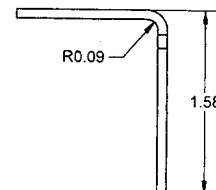
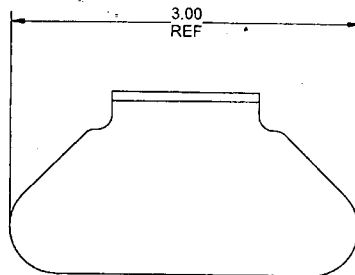
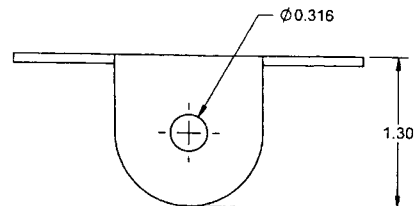
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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\*NOTE: Date & initial all entries







# **D4330-3 DOOR BRACKET**

# 73951

**RELEASED**  
2011-08-16

## **NOTES:**

- 1) MATERIAL: MADE FROM D4330-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.01 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4330	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	11.04.26	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

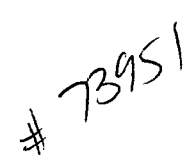
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RELEASED  
2011-08-16  
AM

DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4330	SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET	NTS
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## WORK ORDER CHANGES

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